

Date: Thursday, 23/10/2008 10:54:04 AM
 User: Julie Dawson

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE		
Job Number	42885			Part Number	D29322UP D2933-2UP		
Estimate Number	12930			Drawing Number	D2932 REV C		
P.O. Number				Project Number	N/A D2933 <i>Job 108-10-11</i>		
This Issue	23/10/2008	S.O. No.		Drawing Revision	C		
Prsht Rev.	NC			Material			
First Issue	11	Type	MACHINED PARTS	Due Date	15/11/2008	Qty:	8 Um: Each
Previous Run	41725						
Written By							
Checked & Approved By	<i>JLD 08.10.24</i>						
Comment	Est Rev:A New Issue 07-07-04 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101008 <i>08/10/11</i>	Saddle Billet, 7075	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: <i>B34873</i> - 2	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	<i>JL 08/10/06</i>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<i>JL 08/10/06</i>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<i>JL 08/10/06</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

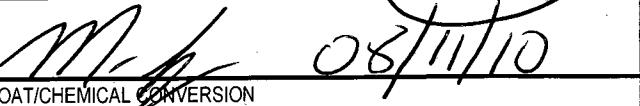
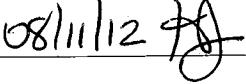
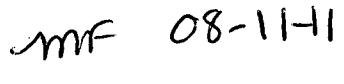
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE	
Job Number: 42885		Part Number: D29322UP	
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
5.0	QC8	SECOND CHECK 	
Comment: SECOND CHECK		JF. 08/11/10 	
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 	
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		MF 08/11/10 	
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 	
Comment: INSPECT POWDER COAT		8/11/10 	
8.0	PACKAGING 1	PACKAGING RESOURCE #1 	
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 425		8/11/10 	
9.0	QC21	FINAL INSPECTION/W/O RELEASE 	
Comment: FINAL INSPECTION/W/O RELEASE		08/11/12 	
Job Completion 		MF 08-11-11 	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	42885 D2932-2
Description: 206 Saddle, Outboard, Right side				Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.112	.114	.114	.117		
B	0.100	0.140		.113	.113	.114	.117		
C	0.100	0.140		.127	.120	.121	.119		
D	0.210	0.230		.218	.219	.219	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.121	.120		
O	0.540	0.560		.544	.549	.548	.550		
P	0.490	0.510		.501	.500	.498	.503		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.492	2.492	2.492	2.492		
S	0.240	0.270		.243	.253	.253	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.318	.318	.318	.318		
X	1.125	1.145		1.134	1.134	1.135	1.133		
Y	1.565	1.585		1.579	1.578	1.578	1.577		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL
Date:	08/11/06

Audited by:	J.F.
Date:	08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	42885
Description: 206 Saddle, Outboard, Right side			Part Number:	D2933-2
Inspection Dwg: D2932 Rev. C			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140	/	.115	.115	.116	.116		
B	0.100	0.140	/	.114	.114	.116	.117		
C	0.100	0.140	/	.120	.117	.119	.120		
D	0.210	0.230	/	.219	.218	.219	.219		
E	1.245	1.255	/	1.250	1.250	1.250	1.250		
F	1.245	1.255	/	1.250	1.250	1.250	1.250		
G	2.495	2.505	/	2.500	2.500	2.500	2.500		
H	0.510	0.515	/	.510	.510	.510	.510		
I	1.572	1.582	/	1.577	1.577	1.577	1.577		
J	2.495	2.505	/	2.500	2.500	2.500	2.500		
K	0.257	0.262	/	.258	.258	.258	.258		
L	0.312	0.317	/	.314	.314	.314	.314		
M	0.235	0.240	/	.238	.238	.238	.238		
N	0.100	0.140	/	.120	.119	.120	.121		
O	0.540	0.560	/	.549	.548	.547	.549		
P	0.490	0.510	/	.498	.498	.500	.499		
Q	3.715	3.725	/	3.720	3.720	3.720	3.720		
R	2.470	2.510	/	2.492	2.492	2.492	2.492		
S	0.240	0.270	/	.253	.255	.253	.253		
T	0.100	0.180	/	.140	.140	.140	.140		
U	1.625	1.635	/	1.630	1.630	1.630	1.630		
V	1.362	1.372	/	1.367	1.367	1.367	1.367		
W	0.316	0.321	/	.318	.318	.318	.318		
X	1.125	1.145	/	1.133	1.134	1.134	1.134		
Y	1.565	1.585	/	1.577	1.577	1.577	1.578		
Z	0.178	0.198	/	.188	.188	.188	.188		
AA									
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Date:	08/11/06	Date:	08/11/07

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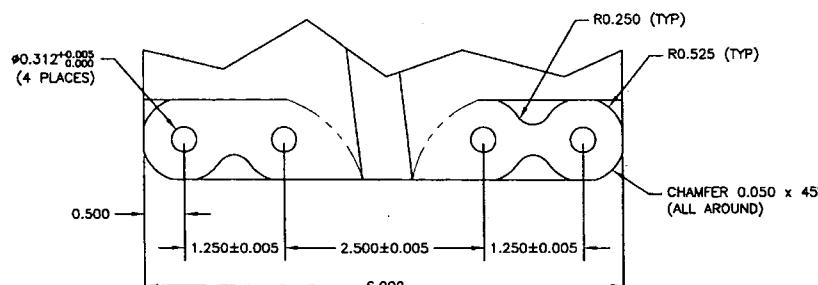
DART AEROSPACE LTD				Work Order:	42885
Description: 206 Saddle, Outboard, Right side				Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.115				
B	0.100	0.140		.116	.115				
C	0.100	0.140		.120	.121				
D	0.210	0.230		.218	.218				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
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M	0.235	0.240		.238	.238				
N	0.100	0.140		.119	.120				
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Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.492	2.492				
S	0.240	0.270		.254	.253				
T	0.100	0.180		.140	.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.318	.318				
X	1.125	1.145		1.134	1.134				
Y	1.565	1.585		1.577	1.578				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	Audited by:	J.F.
Date:	08/11/06	Date:	08/11/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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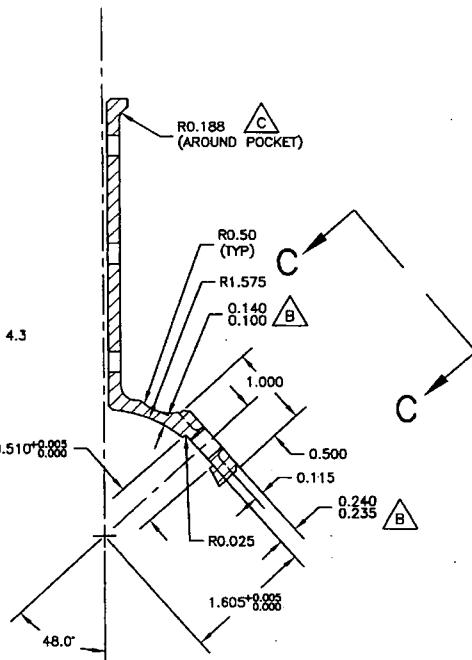


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QO-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

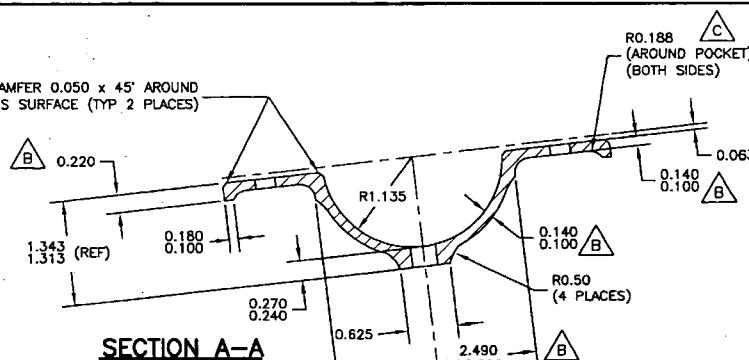


SECTION B-B

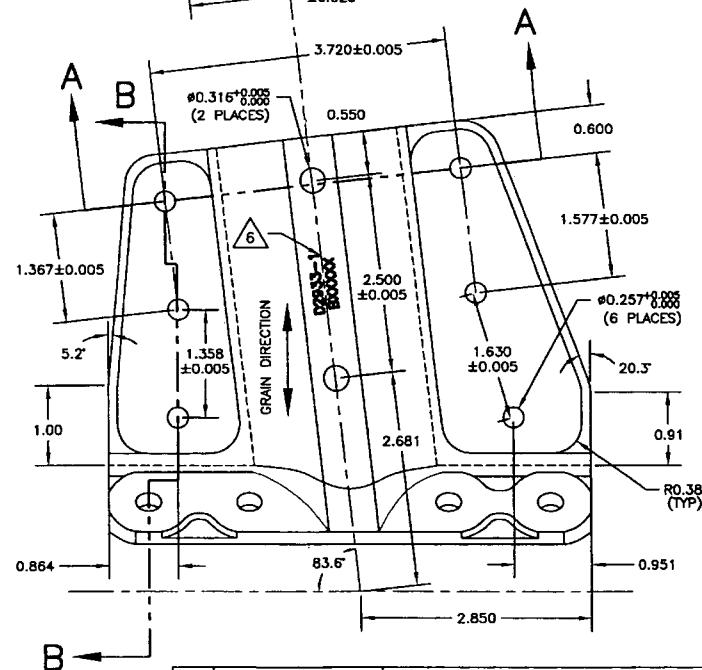
SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 42885

RELEASED
 07-02-12

CHAMFER 0.050 x 45° AROUND
 THIS SURFACE (TYP 2 PLACES)



SECTION A-A



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 AND IS SUPPLIED ON THE EXPRESS CONDITION
 THAT IT IS NOT TO BE USED FOR ANY PURPOSE
 OR COPIED OR COMMUNICATED TO ANY OTHER
 PERSON WITHOUT WRITTEN PERMISSION FROM
 DART AEROSPACE USA, INC.

DESIGN	4	DRAWN BY	CB	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	APPROVED	H	DRAWING NO. D2933
DATE	06.11.09	TITLE	SADDLE INSIDE	REV. C SHEET 1 OF 1 SCALE 2:3